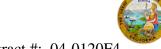
### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: 04-0120F4

Cty: SF/Ala Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-021963 Address: 333 Burma Road **Date Inspected:** 26-Feb-2011

City: Oakland, CA 94607

**OSM Arrival Time:** 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** See below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG** Components

## **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

#### Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW repair welding of weld joint DP3174-001-019 located on PCMK OBG 14W. Welder was identified as 066038. QC was identified as ZPMC CWI Liu Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair as displayed on ZPMC Weld Repair Report B-WR20313 presented to this QA Inspector and verbally identified by QCA1. See photo below of ZPMC Weld Repair Report B-WR20313 as presented to this QA Inspector.

SMAW welding of weld joint DP3172-001-023 located on PCMK OBG 14W. Welder was identified as 067588. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joint SEG3020U-589 located on PCMK OBG 14W. Welder was identified as 067949. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with

## WELDING INSPECTION REPORT

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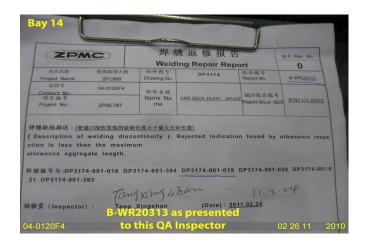
WPS-B-T-2233-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3013M-001 located on PCMK OBG 13AW. Welders were identified as 066421, 667826. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

SMAW welding of weld joint SEG3015B-001 located on PCMK OBG 13CW. Welder was identified as 066443. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW repair welding of weld joint DP3163-001-028 located on PCMK OBG 14E. Welder was identified as 215553. QC was identified as ZPMC CWI Geng Wei (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Ku (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20222 presented to this QA Inspector and verbally identified by QCA2. See photo below of the repair as welded and cleaned.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





## **Summary of Conversations:**

As noted above.

## **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer